

# Work Order ID 52679

October 7, 2009 8:11:40 AM



Page 1

Item ID: D3846-9

Revision ID: B

Item Name: Gasket

Start Date: 10/09/09 Start Qty: 4.00

Required Date: 10/16/09 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: 

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3846

B

100

0.00




Waterjet


FLOW CNC Waterjet

Memo

0.00

1-Cut as per Dwg D3846

Dwg Rev: 

Prog Rev: 

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

MAT NOT PULLED B 9-10-10

(6)

B 9-10-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 52679**

October 7, 2009 8:11:41 AM

Page 2

Item ID: D3846-9

Accept

Revision ID: B

Item Name: Gasket

Start Date: 10/09/09 Start Qty: 4.00

Required Date: 10/16/09 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

2) Solid 13

(86)

/

130

Identify as per dwg & Stock Location Finishing 0.00

Packaging

Memo

0.00

Packaging

09/10/13 (6)

140

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

09/10/19 HJ

u 9.10.16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

October 7, 2009 8:11:39 AM

Page 1

Work Order ID: 52679

Parent Item: D3846-9RevB

Parent Item Name: Gasket

Comments:

Start Date: 10/09/09

Required Date: 10/16/09

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MNEO60S.063		Purchased	No			100	sf	61.6034	7.0522	10.5783		



NEOPRENE SHEET 0.063

B 9-10-10

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		

Main Warehouse

MAT

61.60335853

111853

-4.147E-05

112508

61.6034

112866

112866

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	
<b>Description:</b> Gasket		<b>Part Number:</b>	D3846-9
<b>Inspection Dwg:</b> D3846	<b>Rev:</b> B	<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.300 x 0.300	+/-0.010	303x.304	✓			
1.69	+/-0.030	1.690	✓			
2.39	+/-0.030	2.402	✓			
3.20	+/-0.030	3.208	✓			
4.02	+/-0.030	4.000	✓			
11.50	+/-0.030	11.50	✓			
9.00	+/-0.030	9.00	✓			
18.00	+/-0.030	18.00	✓			
27.00	+/-0.030	27.00	✓			
36.00	+/-0.030	36.00	✓			
60.00	+/-0.030	60.00	✓			
14.49	+/-0.030	14.49	✓			
25.48	+/-0.030	25.48	✓			
28.98	+/-0.030	28.98	✓			
49.32	+/-0.030	49.32	✓			
52.82	+/-0.030	52.82	✓			
54.44	+/-0.030	54.44	✓			
57.94	+/-0.030	57.94	✓			
0.063	+/-0.010	.057	✗			

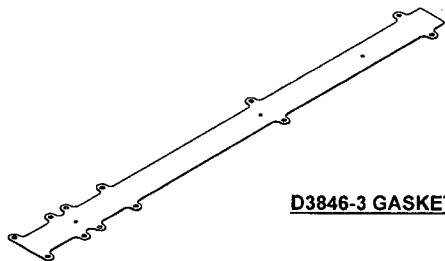
<b>Measured by:</b> RB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 9-10-10	<b>Date:</b> 07/10/13	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.15	New Issue	KJ	A

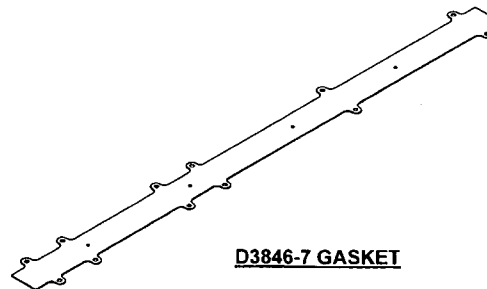
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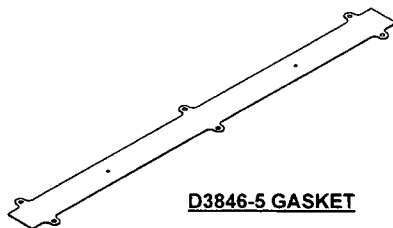
**D3846-1 GASKET**



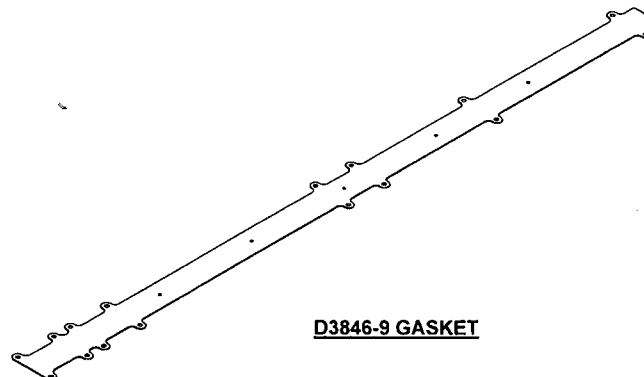
**D3846-3 GASKET**



**D3846-7 GASKET**



**D3846-5 GASKET**



**D3846-9 GASKET**



**D3846-11 GASKET**

**RELEASED**  
09/15/09

**NOTES:**

1) MATERIAL: BLACK NEOPRENE SHEET, 0.063 THICK, 60 DUROMETER  
(REF. DART SPEC. M-NEO60-S.063)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: N/A

6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3846-X" USING YELLOW PAINT MARKER

7) WEIGHT:

D3846-1 = 0.03 lbs

D3846-3 = 0.25 lbs

D3846-5 = 0.20 lbs

D3846-7 = 0.26 lbs

D3846-9 = 0.35 lbs

D3846-11 = 0.04 lbs

B	5.82 WAS 6.25 (ZN C4-2); 45.28 WAS 45.71 (ZN A4-3); 6.32 WAS 6.75 (ZN B2-3)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	PORT HADLOCK, WA	
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3846	SHEET 1 OF 4
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	GASKET	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

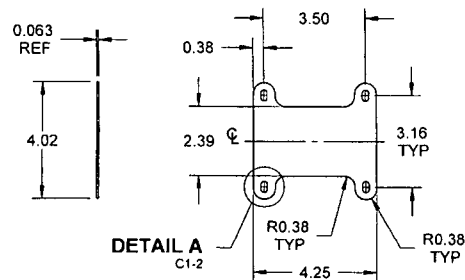
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

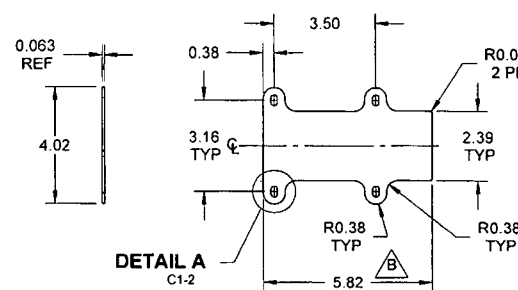
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**NOTE:** Date & initial all entries

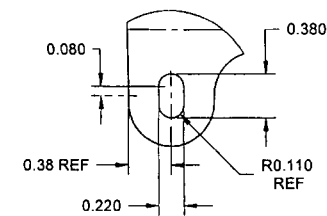
WLO 52679



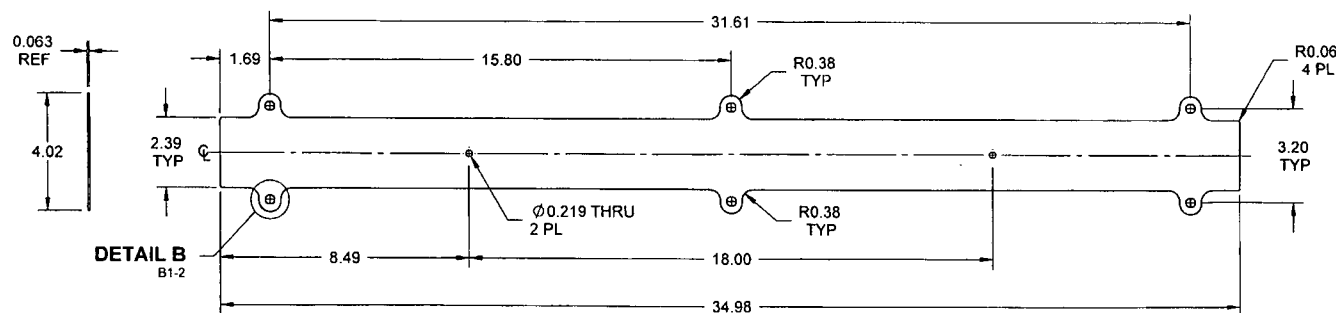
**D3846-1 GASKET**



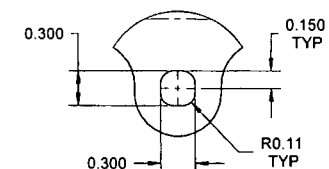
**D3846-11 GASKET**



**DETAIL A** C5-2  
TYP. SCALE 4X C7-2



**D3846-5 GASKET**

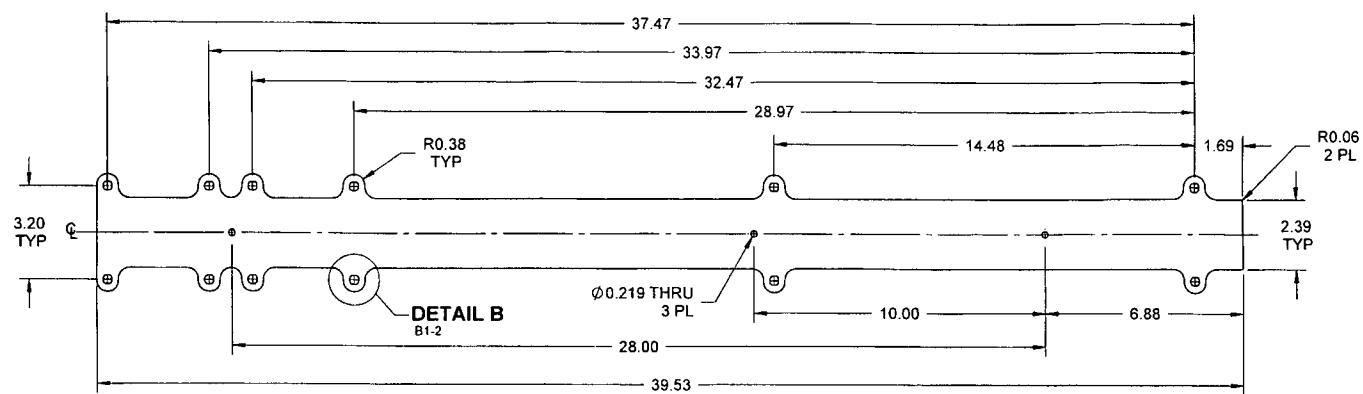
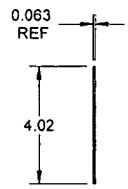


**DETAIL B** A7-2  
TYP. SCALE 4X C5-3  
C5-4 B7-3

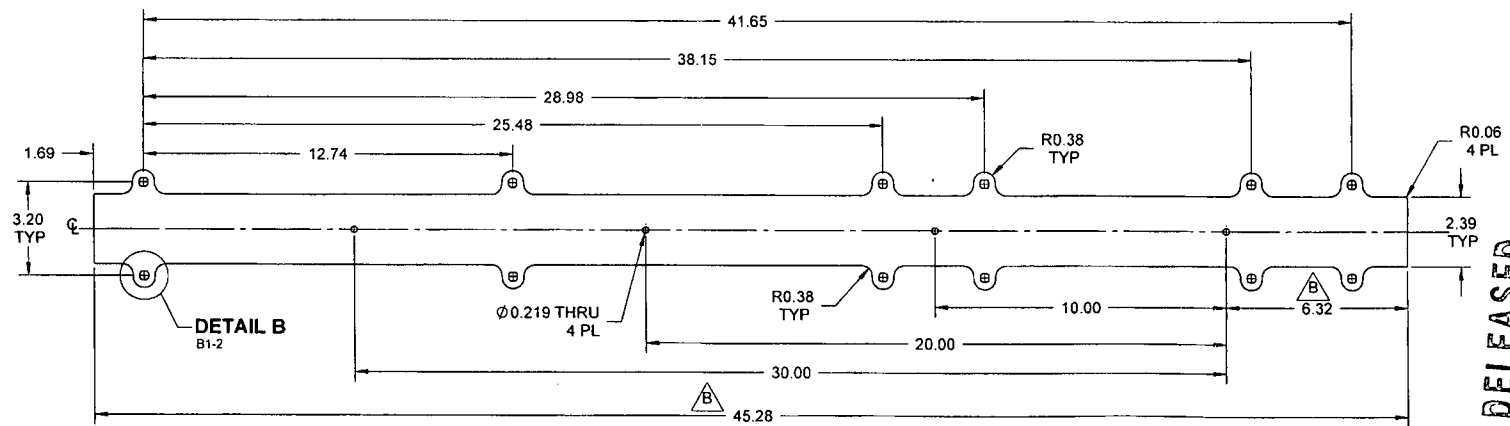
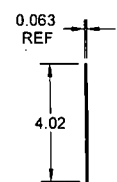
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9/15/14

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**D3846-3 GASKET**

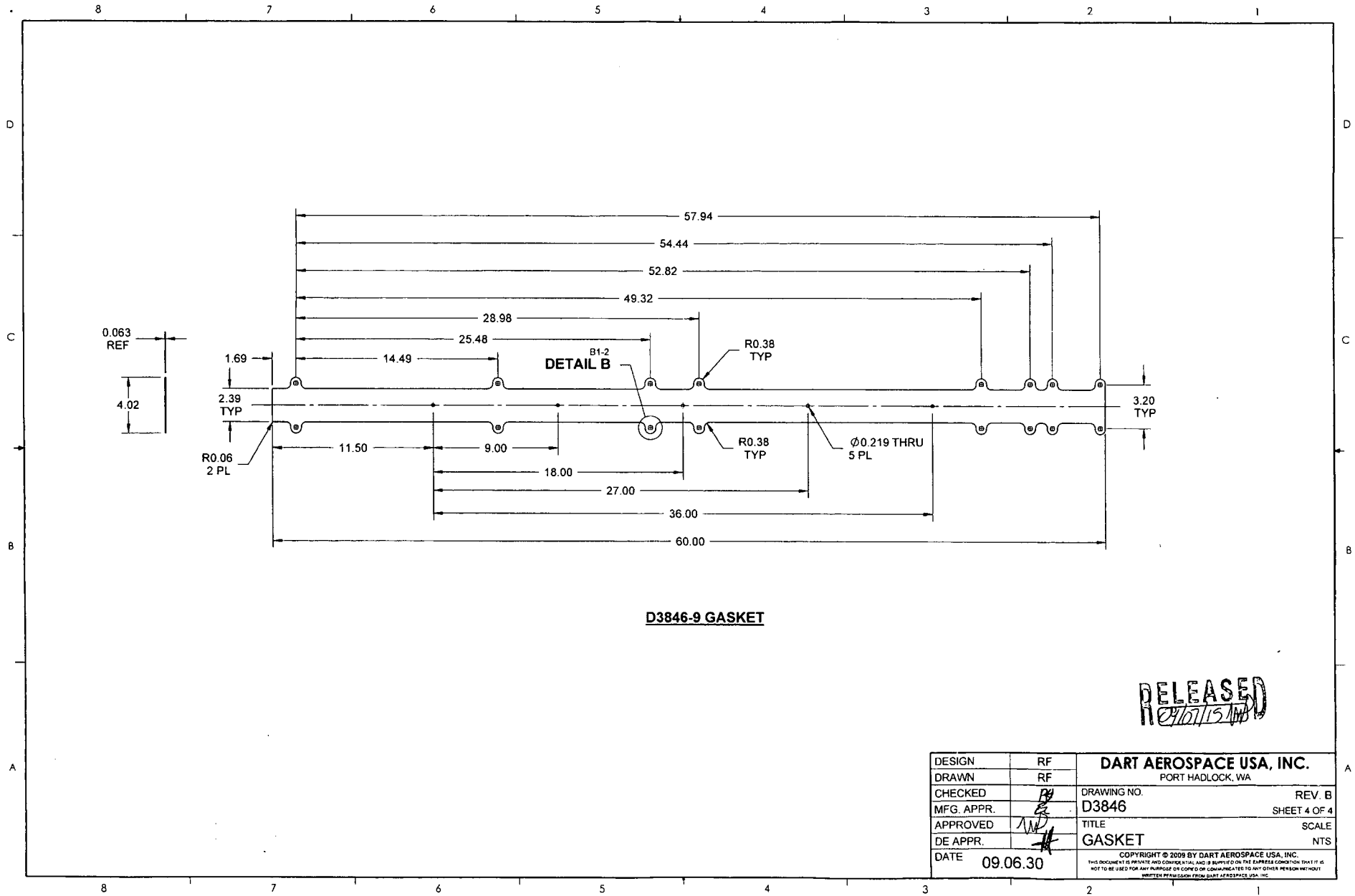


**D3846-7 GASKET**

RELEASED  
2015/15/16

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W/052679



D3846-9 GASKET

RELEASED  
2015

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CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3846	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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